

## ABSTRACT OF THE DISCLOSURE

A vise for holding more than one work piece on the support surface of a machine tool has a base for mounting on the support surface. More than one stationary jaws are fastened to the base. More than one movable jaws are slidably mounted on the base to move toward and away from the stationary jaws to securely hold at least one work piece between each pair of a stationary and a movable jaw. Movement of the each movable jaw is provided by a first mechanism that closes on the work piece snugly to accommodate minor variations in work piece dimensions. A second movement mechanism moves all of the movable jaws with great force including a spring bias to tightly clamp all of the work pieces at once with enough force to enable machine operations on the work pieces with no chance of their moving from the machining operations.